Quality Control

D3594-043 Accept Setup Start Item ID: **Revision ID:** Stop Floor Doubles Assembly, LH Item Name: **Start Date:** 14/12/2009 Start Oty: 8.00 Cust Item ID: Required Date: 18/12/2005 Req'd Qty: 8.00 **Customer:** Reference: Start Run Tooling: Process Plan: Date: Approvals: Stop SPC (Y/N): QC: Date: Date: Reject Reject Accept Sequence ID/ Operation Set Up/ Draw Draw Plan Qty **Qty** Stamp Work Center ID Description Run Hours Number Rev. Code **Revision Nbr** Draw Nbr D3594 Rev B 0.00 100 FLOW WATER JET B-10-1-6 0.00 Waterjet FLOW CNC Waterjet Deburr if necessary 600 , 080 0.00 110 QC2- Inspect parts off machine FAI/FAIB R 10-1-6 0.00 Memo Quality Control QC8- Inspect parts - second check 120 Memo

	Dart	Aer	OS	pace	Ltd
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W/O:			WO	RK ORDER CHANGI	ES			······································	<u> </u>
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	4 :	_ Date: _	
	R	esolution:	Disposition	ı:	QA: N/C C	losed:		Date: _	
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			
		Description of NC		Corrective Action Section	on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& _{Secti}		Chief Eng	QC Inspector
									}
					3				

Work Order ID 54579 December 14, 2009 10:45:57 AM

Page 2

Required Date: 18/12/2009

Item ID:

D3594-043

Accept



Setup Start

Stop



Revision ID:

Item Name:

Floor Doubler Assembly, LH

Start Date:

14/12/2009

Start Cty: 8.00 Req'a Oty: 8.00

Cust Jem ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

130

Small Fab

Operation **Description**

Small Fab

C'SINK AS PER DWG D3594

Set Up/ **Run Hours**

Draw Draw Number Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Stamp

Small Fab

Memo

0.00

0.00

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O



150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

0.00

bk 10-01-12 5



Hand Finishing

Dart Aerospace Ltd	erospace Ltd
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	•								7 ,
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
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Part No):	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	\:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Clo	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
		Description of NC		Corrective Action Section	ion B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
							<u>.</u>		

December 14, 2009 10:45:58 AM

Required Date: 18/12/2009

Item ID:

D3594-043

Accept

Setup Start

Stop





Revision ID:

Item Name:

Floor Doubler Assembly, LH

Start Date:

14/12/2009

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:



QC:

Date:

SPC (Y/N):

Date:

Stop

Run

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours** 0.00

Draw Number Draw Rev.

Accept Qty

Plan

Code

Reject Qty

Reject Number Stamp

Memo

10.01-12

170

Small Fab Small Fab

Small Fab

Memo

Memo

Install Nut Plates As per Dwg D3594

0.00

0.00

Estopopia 15

180

Quality Control

QC5- Inspect part completeness to step on W/O

2) S 10/01/13

Dart Aerospace Ltd

Dail Ac	ospace	Liu								,
W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	QA	: N/C CI	osed:		Date: _	
NCR:		V	VORK ORE	DER NON-CONFO	RMANCE	(NCF	R)			
DATE	OTED	Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign 8 Date		ion C	Chief Eng	QC Inspector
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Work Order ID 54579



Page 4

December 14, 2009 10:45:58 AM

Required Date: 18/12/2009

Item ID:

D3594-043

Accept



Setup Start

Stop



Revision ID:

Item Name:

Floor Doubler Assembly, LH

Start Date:

14/12/2009

Start Oty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

Start

Date:

SPC (Y/N):

Date:

Run

Sequence ID/ **Work Center ID**

190

Packaging

Operation Description

Identify as per dwg & Stock Location:_____

Set Up/ **Run Hours**

0.00

Number

Draw

Plan Draw Rev. Code

Accept Qty

Reject

Reject Number Stamp

Packaging

Memo

Memo

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

me 10-1-13

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W/O:			WORK ORDER C	HANGES				
DATE	STEP	PROC	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	R	esolution:	Disposition:	QA: N/C	Closed:		Date: _	

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annroval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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						-		
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Picklist Print December 14, 2009 10:46:01 AM Work Order ID: 54579 Parent Item: D3594-043 Parent Item Name: Floor Doubler Assembly, LH



Required Date: 18/12/2009

Page 1

Start Date: 14/12/2009

Comments:								S	Start Qty: 8.00		Required Qty: 8	.00
s smponent Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Pri wary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining ** Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-4	11111 1111 1111 1111 1111 1111 1111 1111	Purchased	No			100	Each	2,675.000	16.0000	£ 10	10,/13	
				Wareho	use	Loc	<u>Oty</u>	Loc Code			7	
				Loc	ation_							
				Main Wa	arehouse				•			
				ST			2675			80		
					15541	150	2675	24 2000		30		
M6061T6S.080		Purchased	No			170	sf	34.3809	4.2947	(2)	18/0	-1-6
0001 10 .000 Sheet				Wareho	use	Loc	Oty	Loc Code			_	
				Loc	<u>ation</u>							
				Main W	arehouse							
				MA	Т	34	38087					
					110630 112141		8.5136 86727		-	13438		
MS21069-5		Purchased	No		113438	170	Each	12.0000	8.0000	13.420	, /	•
		i urchasea								JS 10	101/1	3
Anchor nuts				<u>Wareho</u> <u>Loc</u>	ouse ation	Loc	: Oty	Loc Code				
				Main W	arehouse							
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					111310		12		_			

M113627

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	es N	o DQ /	A :	Date:	
	R	esolution:	Dispositio	n:	QA: N/C	Clos	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			2300	
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti	on C	Chief Eng	QC Inspector
	-									

DART AEROSPACE LTD	Work Order:	54579
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Tolerance Actual Dimension Accept Reject Method of Inspection		L _				
7.85		Tolerance	1	Accept	Reject	Comments
7.313	12.25	+/-0.030	13.34	>		
7.313	7.85	+/-0.030	7.856	×		
2.688	7.313	+/-0.010	1			
Ø0.323 +0.006/-0.001 、333 メー Ø0.126 +0.005/-0.001 、138 メー 0.359 +/-0.010 -360 χ 0.718 +/-0.010 720 χ 0.81 +/-0.030 .827 メー 2.32 +/-0.030 2.328 χ 0.080 +/-0.010 .677 χ	2.688	+/-0.010		L		
∅0.126	Ø0.323	+0.006/-0.001		1 "		
0.359	Ø0.128	+0.005/-0.001		*		
0.718	0.359	+/-0.010		1 '		
0.81	0.718	+/-0.010		1 '		
2.32 +/-0.030	0.81	+/-0.030		T		
0.080 +/-0.010 077 7	2.32	+/-0.030	,	1 '		
	0.080	+/-0.010		1 .		
		, .				

Measured by:		Audited by:	8	Prototype Approval:	N/A
Date: jo	>1-6	Date:	10/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue P/O D3594-043	KJ/JLM	
В	08.09.04	Dwg Rev updated	KJ/DD 3 A	A1
С	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC C	- N
	*			

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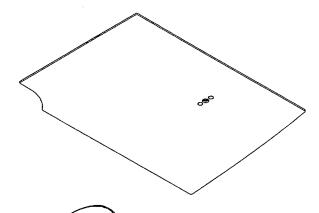
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DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			,							

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC Corrective Action Section B Verificatio					on Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng			Section C	Chief Eng	QC Inspector		
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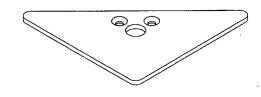
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D3594-041 DOOR DOUBLER ASSEMBLY

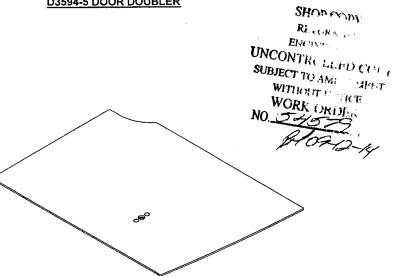


Ø3594-043 PLOOR DOUBLER ASSEMBLY

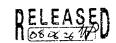
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D3594-5 DOOR DOUBLER



D3594-044 FLOOR DOUBLER ASSEMBLY



В	REFOR	MAT TO B SIZE	DRAWING. SHEET 2 ADD -5.	AJS	08.05.14			
Α	NEW IS	SUE		MB	07.04.13			
REV.		DESCRIPTION			DATE			
DESIG	N	MB	DART AEROS	PACE L'	TD			
DRAW	N	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECK	CHECKED		DRAWING NO.		REV. B			
MFG. A	PPR.	12	D3594	SHEET 1 OF 4				
APPRO	VED	142	TITLE	SCALE				
DE API	DE APPR.		DOUBLER	_	NTS			
DATE	08.0	5.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THE DOCUMENT & PRANTE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MAY PURPOSE OR COMPLIANCE TO TO ANY OTHER PERSON WITHOUT WRITTEN PERSONS ON PROM DART APROSPACE TO.					

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W/O:			WO	RK ORDER CHANGES	· · · · · · · · · · · · · · · · · · ·				
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NCR:			WORK ORDE	R NON-CONFORMANO	CE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section			Verific	ation	Approval	Approval
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								Established	
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. 2 5 QTY. PART NUMBER DESCRIPTION R0.13 TYP D3594-041 DOOR DOUBLER ASSEMBLY D3594-1 DOOR DOUBLER 0.530 MS21069L5 ANCHOR NUT 0.718 0.359 MS20426AD4-4 RIVET, CSK (\otimes) Ø0.128 THRU ® Ø0.248 X 100° CSK D3594-1 DOOR 2 PL 1.000 DOUBLER 45° Ø0.323 REF MS20426AD4-4 RIVET 1.000 С Ø0.128 THRU Ø0.248 X 100° CSK **D3594-1 DOOR DOUBLER** 2 PL 0.508 R0.13 REF TYP 0.359 0.530 2 PL (8) DETAIL A SCALE 2X 1.000 MS21069L5 ANCHOR NUT Ø0.323 REF (4) D3594-041 DOOR DOUBLER ASSEMBLY 1.000 -2.57 2 PL NOTES:
i) MATERIAL: -1 & -5 5 D3594-5 DOOR DOUBLER B 1) MATERIAL: -1 & -3 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080) 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 DESIGN МВ DART AEROSPACE LTD AUS DRAWN 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
3) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3594 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED ') BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX ') WEIGHT -041: 0.04 lbs SCALE

8

-5: 0.03 lbs

7

5

3

DE APPR

08.05.14

DATE

2

DOUBLER

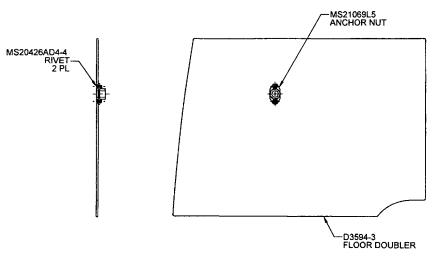
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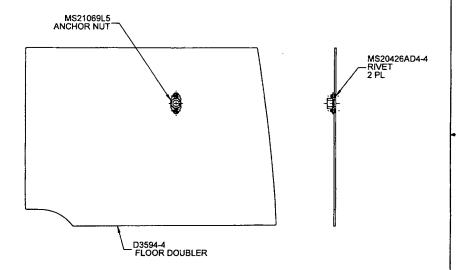
Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	jory:	NCR: Yes No DQA: Date:				
Resolution:			Disposition	QA: N/C Closed:			Date:		
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DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C		QC Inspector
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION		
X	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH		
	Х	D3594-044	FLOOR DOUBLER ASSEMBLY, RH		
1		D3594-3	FLOOR DOUBLER, LH		
	1	D3594-4	FLOOR DOUBLER, RH		
1	1	MS21069L5	ANCHOR NUT		
2	2	MS20426AD4-4	RIVET, CSK		



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

arly 545 79 DELEASED

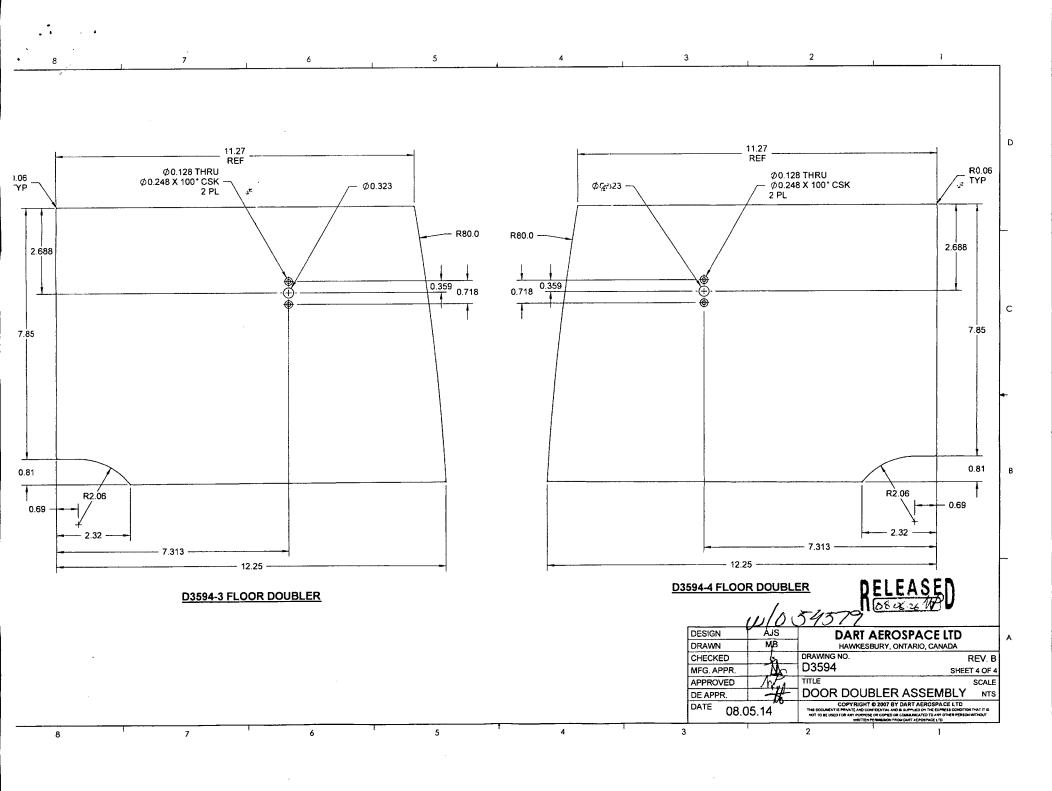
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	arli	1 G70) /7		
	DESIGN	MB	DART AERO	SPACE LTD	
	DRAWN	AJSI	HAWKESBURY, ONTARIO, CANADA		
	CHECKED	- 4	DRAWING NO.	REV. B	
	MFG, APPR.	77	D3594	SHEET 3 OF 4	
	APPROVED	149	TITLE	SCALE	
	DE APPR.	7	DOUBLER	NTS	
	DATE 08.0)5.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THE DOCUMENT REPRIATE AND COMPERENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS		

NOTES:
1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -043 & -044: 0.80 lbs

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cate	NCR: Yes No DQA: _				Date:				
Resolution:			Dispositio	_ QA: N/C Closed:				Date:				
NCR:		\	NORK ORDI	ER NON-CONFORMA	ANCE	(NCR)						
DATE	STEP	Description of NC	Corrective Action Section					ation	Approval	Approval		
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector			
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Dart Aerosp	ace Ltd
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W/O:			WC	RK ORDER CHANG	SES							
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Part No: PAR #:		PAR #:	Fault Category: NO			CR: Yes No DQA: Date:						
Resolution:			Disposition:			QA: N/C Closed: Date:						
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DATE	STEP	Description of NC			ection B		Verification		Approval	Approval		
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